green

Dart Aerospace Ltd.

3

Date: Wednesday, 11/21/2007 12:46:51 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 205 SKID INSTALLATION KIT
Job Number	: 35913		
Estimate Number	: 12519		
P.O. Number	: N/A	**Part Number**	: D205634015
This Issue	: 11/21/2007 **S.O. No.** : N/A	**Drawing Number**	: IIN D205-634 REV D
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: D
Previous Run	: 35912	**Material**	: N/A
Written By	:	**Due Date**	: 1/15/2008 **Qty:** 1 **Um:** Each
Checked & Approved By	: 07.11.21		
Comment	: Est Rev:A New Issue 00-04-04 EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	KS 07.12.07
	Comment: Photocopy bluefile & type labels per PPP205-634-015 CHG 004		08/01/15
2.0	35913A	SKID TUBE ASSEMBLY	#35913A
	Comment: Sub-Component SKID TUBE ASSEMBLY		AS 08/01/15 (x1)
3.0	K10003	D205-634-011 Saddle Kit	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) D205-634-011 Saddle Kit	35914	AS 08/01/15 (x1)
4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS	
	Comment: INSPECT 100% KITS FOR COMPLETENESS		08/01/15
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D205-634-015 Location:______ PPP Rev: E		AS 08/01/15 (x1)
6.0	QC21	FINAL INSPECTION/W/O RELEASE	
	Comment: FINAL INSPECTION/W/O RELEASE		08/01/16

Job Completion 2008/1/16

Form: mprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** AD **Date:** 08/01/16

QA: N/C Closed: _____ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					**D205-634-011**	**SKIDTUBE INSTALLATION (STANDARD)**
		X				**D205-634-015**	**SKIDTUBE INSTALLATION (MODIFIED)**
	1		X			**D205-634-041**	**SKIDTUBE**
		1		X		**D205-634-045**	**SKIDTUBE**
	1	1			X	**D205-641-011**	**GROUND HANDLING KIT**
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D2968-041	TOW RING
41	1	1				AN970-4	WASHER
43	1	1				MS21042L4	NUT (OR MS21042-4)
50					1	D2736-1	GHW LUG
51					1	D2736-3	GHW LUG
52					4	AN4-46A	BOLT
53					8	D2570	BUSHING
54					4	MS21042L4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

-015

Dart Aerospace Ltd.

3

Date: Wednesday, 11/21/2007 12:47:10 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 35913A
Estimate Number : 12520
P.O. Number : N/A
This Issue : 11/21/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LANDING GEAR
Previous Run : 35912A
Written By :
Checked & Approved By : 07 11 21
Comment : Est Rev:C Revised Steps 06-09-06 JLM
Est Rev:D Added SS Wearplates & Gaskets 07-07-09 JLM

Drawing Name : SKID TUBE ASSEMBLY
Part Number : D205634045
Drawing Number : D2580 REV D
Project Number : N/A
Drawing Revision : D
Material : N/A
Due Date : 1/15/2008 Qty: 1 Um: Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy D205-634 bluefile & type labels per PPP D205-634-045 CHG002 N/A

2.0	D25001190	Ext'n -'I' Beam Tube 4"

Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B34229

07-11-23

3.0	D2596	205 Web

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	35996

SL 7-11-28

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessaryDeburr ends 7-11-23

3-Drill pilot holes using drill jig DT 8149

4-Acid etch and Alodine tube per QSI 005 4.1 SL 7-11-26

Form: process

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 35913A **Part Number:** D205634045

Job Number:

Seq. #:	Machine Or Operation:	Description :

5-Open holes to 0.500" as per Dwg D2580without cutting fluid

6-Countersink holes as per Dwg D2580without cutting fluid

7-Deburr and blow out all chips from inside of tube

SL 7-11-27

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

SL 7-11-28

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	105488	

Sikaflex expire date: 8-7-1

Start Time: 7:15 Date: 7-11-28

Fin Time: 8:30 Date: 7-11-29

5.0	BENDING	BENDING MACHINE

Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL 7-11-29

6.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

SL 7-11-29

2-Drill extra fwd hole as per DEO 9183 using drill jig DT8461

3-Drill extra middle hole as per DEO 9183 using drill jig DT8462

4-Drill pilot holes for aft cap using DT8215, ***DO NOT OPEN TO FINISH SIZE***

5-Drill extra aft holes as per DEO 9183 using drill jig DT8463 locating from aft cap hole and aft saddle hole.

7.0	QC5	INSPECT WORK TO CURRENT STEP

7-12-06

Comment: INSPECT WORK TO CURRENT STEP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:47:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35913A

Part Number: D205634045

Job Number:

Seq. #:	Machine Or Operation:	Description :
8.0	D25763	Step (Machining Detail)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	B33464 BE 07-12-11

Seq. #:	Machine Or Operation:	Description :
9.0	D2579	Crossbolt Spacer

Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
24	D2579	Spacers	B34347 BE 07-12-11

Seq. #:	Machine Or Operation:	Description :
10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required. BE 07-12-11

2-Weld step D2576 as per Dwg. D2580 and QSI 004.
A/R Aluminum Rod M106035 BE 07-12-11

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R Aluminum Rod M106035 BE 07-12-11

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending — AWM 07-12-20

5-Drill holes for wearplates using DT 8217Open holes to 19/64", adjust stopper not to hit web.Deburr AWM 07-12-20

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes **************DO NOT COUNTERBORE EXTRA HOLES PUT IN AT STEP 13,14 AND 15 (LEAVE AT 0.384"Ø AS PER DEO 9183)**** SL 7-12-24

7-Open aft cap holes to #6 Drill bit. Deburr AWM 07-12-20

8-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr SL 7-12-24

Form: mprocess

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:47:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35913A

Part Number: D205634045

Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION — 07/12/28

12.0	QC5	INSPECT WORK TO CURRENT STEP

07-12-31 ①

Comment: INSPECT WORK TO CURRENT STEP

13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

(1X)

Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005 — 08/01/09

14.0	POWDER COATING	POWDER COATING

M102316 (1X)

Comment: POWDER COATING
Powder Coat ****GREEN****Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3 — 08/01/09

15.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION — BK 08-01-09

16.0	D2855	Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cap
Batch: B35920 — BK

17.0	AN35A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M100188 — BK

18.0	AN960JD10L	Washer

(PTO)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M104374 — BK

BK 08-01-10 ①.

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
* 08-01-09	18.1	50 WASHER AN 960 C10L M 106662	BR	08-01-09	50		08/01/11

Part No: ______ PAR #: ______ Fault Category: ______ NCR: Yes No DQA: ______ Date: ______

QA: N/C Closed: ______ Date: ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:47:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 35913A **Part Number:** D205634045

Job Number:

Seq. #:	Machine Or Operation:	Description :
19.0	ALS71032130	Insert
	Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s) Insert Batch: m 105729	
20.0	AN3C4A	BOLT
	Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s) BOLT Batch: m 106513	
21.0	D356613	GASKET
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GASKET Batch: B32744	
22.0	D35665	GASKET
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GASKET Batch: B36113	
23.0	D35661	GASKET
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) GASKET Batch: B36339	
24.0	D356413	WEARSHOE
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: B33867	
25.0	D356411	WEARSHOE
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: B34352	

BK 08-01-10 ⑦

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35913A

Part Number: D205634045

Job Number:

Seq. #:	Machine Or Operation:	Description :
26.0	D35649	WEARSHOE
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: B36023	
27.0	D35645	WEARSHOE
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: B36111	
28.0	D25943	O-Ring
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s) O-Ring Batch: B27168	
29.0	D25941	Plug
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s) Plug Batch: ~~B33450~~ ~~B 25941~~	B33450 2008/1/16
30.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 M105487
Sikaflex expire date: 08-01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R Sikaflex-291 M105487
Sikaflex expire date: 08-01

08-01-10 ①.

5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: M106332
M106332 - 08-01-11 (1X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 08/01/16

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:47:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35913A
Part Number: D205634045

Job Number:

Seq. #:	Machine Or Operation:	Description :
31.0	QC5	INSPECT WORK TO CURRENT STEP

08/01/11

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

Seq. #:	Machine Or Operation:	Description :
32.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-634-045
Location:________
PPP Rev: P.P.P35913

AS 08/01/15 (X1)

Seq. #:	Machine Or Operation:	Description :
33.0	QC21	FINAL INSPECTION/W/O RELEASE

(1)

Comment: FINAL INSPECTION/W/O RELEASE

08/01/16

Job Completion

2008/1/16

35913A

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580 — REV. D — SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY — SCALE NTS

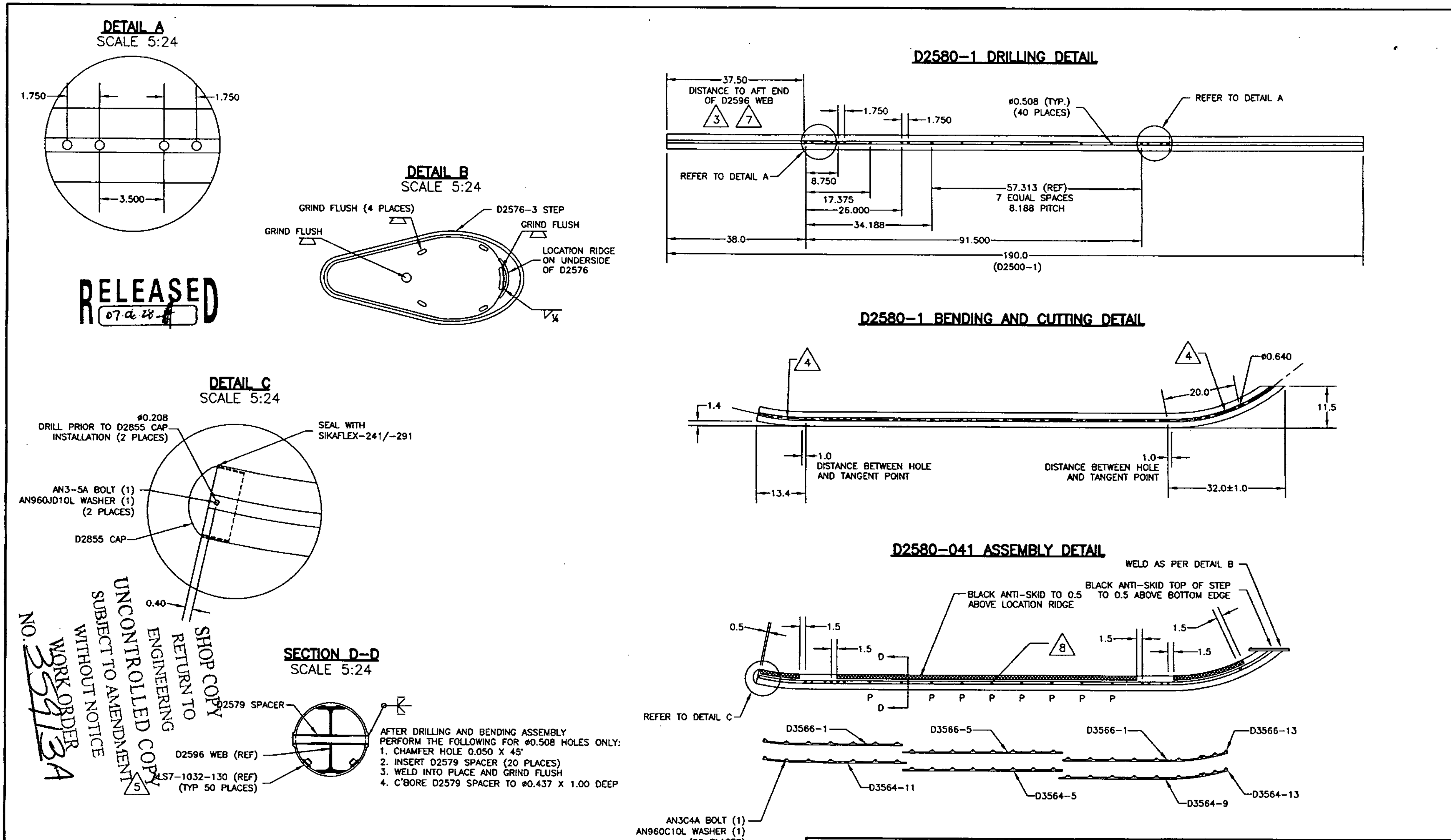
A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183

RELEASED 07.06.28

QTY -041	QTY -045	Part Number	Description
X		**D2580-041**	**SKIDTUBE ASSEMBLY**
	X	**D2580-045**	**SKIDTUBE ASSEMBLY**
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

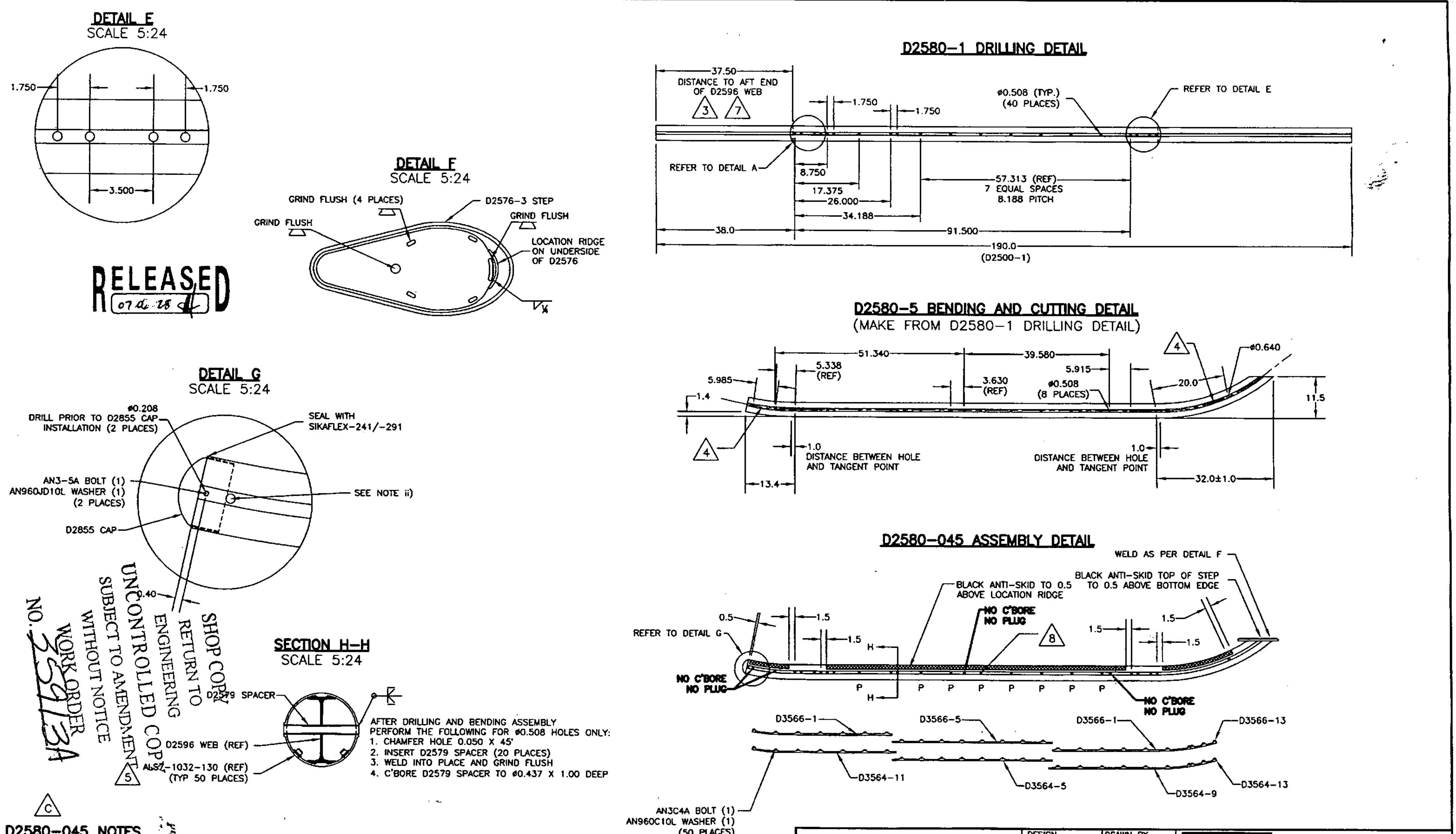
1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) ALL DIMENSIONS ARE IN INCHES
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
   SEE NOTES ON
   PAGE 2 FOR D2580-041 AND
   PAGE 3 FOR D2580-045
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).



D2580-041 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580 — REV. D — SHEET 2 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY — SCALE 1:24



D2580-045 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
RH	RH	
CHECKED	APPROVED	DRAWING NO. D2580 — REV. D — SHEET 3 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY — SCALE 1:24

NO. 133

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliot
Joint Welding Procedure tig
Part number and Job number D205 634 041 / 535642

TEST WELDS REQUIRED

BASE METAL Aluminium
Penetration Complete [ ] Partial [✓]
Current AC [✓] DC [ ]

WELDING PROCESS tig
Single Weld [✓] **Double Weld** [ ]
Backing YES [ ] NO [✓]

	Position		**Vertical** Down [ ]	Up [ ]
Sheet Groove	1G [ ]	2G [ ]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [ ]	5G [✓]	6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [ ]	4F [ ]	5F [ ]

Crossbolt Spacer Welded into N/A Skidtube

TEST RESULTS

Visual	Pass [✓]	Fail [ ]
Penetration	Pass [✓]	Fail [ ]
Crossbolt Spacer	Pass [✓]	Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07-11-27 **Qualifier** [signature]

H:\FORMS\Production\approved.prod.\Welding Coupon.Rev.A